



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18582
Job Sheet 184699



Part No: RBT18582

Job Qty: 10 ea

Part Name: Tail Rotor Gear Box Torque Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/29/18

Created By: Logan David

Type: SOLD

Description: Navair Order 1515

Note: DWG RBT18582 Rev1 IPP Rev A 17.11.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/29/18	10/29/18	0.00	0.00	Start Up Small Fab-4		MLC
95	HandFinish	10 pcs	10/29/18	10/29/18	0.00	1.00	HandFinish7		REB 18-11-01
100	Small Fab	10 pcs	10/29/18	10/29/18	0.00	2.00	Small Fab-9	1 1/2	JBC
110	QC	10 pcs	10/29/18	10/29/18	0.00	0.00	QC5		SL
120	Large Fab	10 pcs	10/29/18	10/29/18	0.00	5.00	Large Fab 1		MLC
140	QC	10 pcs	10/29/18	10/29/18	0.00	0.00	QC9		MLC
180	Outsource	10 pcs	10/29/18	10/29/18			GRO002-VC	5	MLC
190	Packaging	10 pcs	10/29/18	10/29/18	0.00	0.00	Packaging2		NOV 18-11-5
200	QC	10 pcs	10/29/18	10/29/18	0.00	0.00	QC6		NOV 18-11-5
210	Packaging	10 pcs	10/29/18	10/29/18	0.00	0.00	Packaging3-1		NOV 18-11-5
220	QC21-FG	10 Ea	10/29/18	10/29/18	0.00	0.00	QC21		NOV 18-11-5

Part Op 95 - Bead blast remove all chrome

Descriptions: 100 - 1-HEAT and form wrench as per DWG using press. 2-Cut off excess wrench and finish end as per DWG.

120 - 1-Weld socket as per DWG note 1 2-Clean up welds using wire wheel

180 - Issue P/O to Groupe Altech: P/O 41603 -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required

210 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
84504158	Wrench	10 Ea (1 ea)	90-Start up Operation	1X 5027216 6X5033915
RBT18582-5	Socket, Modified	10 Ea (1 ea)	120-Large Fab	5122917

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	84504158	10	7	0
120-Large Fab	RBT18582-5	10	1	0

Part Specifications

Specifications could not be found.



Container No: S123783



Part: RBT18582
Job No: 184699
Serial No/Batch: S123783
Revision: 1
Inspector:
Exp Date:
Instructions:

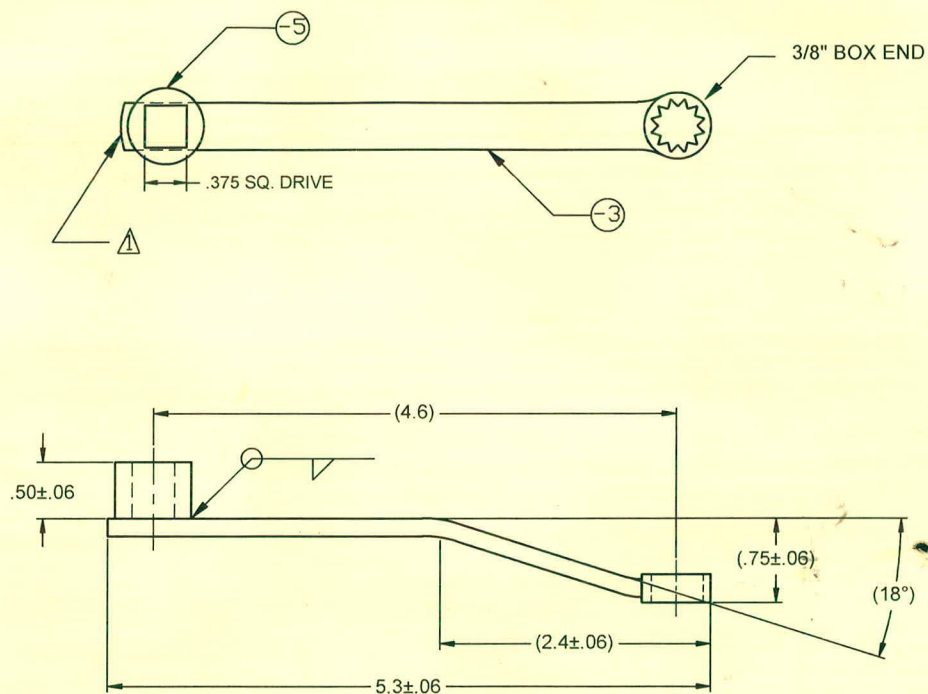
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/01/10

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D REF. DIM FROM 5.75 TO 4.5, ADDED REF. DIM. 2.4 & 18° PER R.W.	11/28/11	RJC	RW
1	ADDED TOLERANCE $\pm .06$ TO .50, 5.3, 2.4 & .75 DIMS, CH'D OVERALL LENGTH FROM 5.2 & LENGTH BETWEEN CENTER OF WRENCH AND SOCKET FROM 4.5, CH'D TOOL NAME FROM WRENCH PER D.W.	3/14/12	RJC	DW



△ BELOW INFORMATION FOR OUTSIDE OPERATION

1. FORM WRENCH
2. WELD SOCKET TO REF. LENGTH
3. CUT EXCESS WRENCH & FINISH END

NOTE:

1. REMOVE WELD MARKS WITH WIRE WHEEL.
2. TOOL ALSO SOLD W/KIT RBT18561.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
	X		-1	1	WELDMENT		
	1		-3		WRENCH	3/8" 12pt. BOX END PROTO #212ASD (MSC #84504158)	
	1		-5		SOCKET	3/8" DR. 9MM PROTO #5209M (MSC #70548573)	
ASSY #							

RED BARN MACHINE	
TITLE T/R G/B TORQUE ADAPTER	
DWG NO. RBT18582	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX $\pm .005$ XX $\pm .01$ X $\pm .1$	
FRACTIONS $\pm 1/32$ ANGLES $\pm 5^\circ$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7-17-09
SHEET 1 of 1	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041663**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041663
PO Date: 11/8/18
Due Date: 11/15/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments: ** Please advise date of delivery **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184699	RBT18582	Tail Rotor Gear Box Torque Adapter -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	-	11/15/18	7 pcs	0 pcs	7 pcs	\$12.857142/pcs	\$90.00

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NOV 14 2018

[Signature]

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Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/8/18 2:25 PM dart.tsimiklis.chrisoula

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Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014252- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
13-Nov-2018		Ross Montieth		041663 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18582 ✓ Rev.	RBT18582 ZINC PLATE, ASTM B633 TYPE 1 SC2	ZINC CH	7	7 ✓	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

SAC
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